

ABSTRACT OF THE DISCLOSURE

The dope prepared from a mixture solvent and solid contents
5 such as cellulose ester and additives is cast on a drum cooled
to -5°C to form a gel-like film. The gel-like film is peeled
off from the drum. Tension of 60 kg/m is applied to the gel-like
film in the widthwise direction thereof and the temperature of
the gel-like film is kept 120°C , when the content of the solvent
10 to the solid contents in the gel-like film is in a range of 100
wt.% to 20 wt.%. Further the gel-like film is dried to be a
cellulose ester film having 40 μm thickness. The IR spectrum
of the cellulose ester film has a peak in a range of 520 cm^{-1}
to 480 cm^{-1} which indicates the crystallization of the polymer.
15 The cellulose ester film has tear strength of 12g, Rth of 42nm
and Re of 1.2 nm. As crystallization of the polymer proceeds,
the cellulose ester film has sufficient strength and optical
properties.